

Work Order ID 70294

Thursday, June 02, 2011 1:41:48 PM



Page 1

Item ID: D3202-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Cover

Start Date: 6/9/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3202	Rev D								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

5050.037

1-Cut as per Dwg D3202

Dwg Rev: *D*

Prog Rev: *D*

2-Deburr if necessary

B11-6-13

(30)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-6-13

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Plan:

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Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

140

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

10:30
320 OF
11:00

30x Ø M-11/06/13

30x Ø M-11/06/14

M115128

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Page 3

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Required Date: 6/17/2011 Req'd Qty: 24.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

30 0 BL 11-6-14

160

Identify as per dwg & Stock Location: 241A

0.00



Packaging

Memo

0.00

Packaging

11/4/15 30

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/15 ME 11-06-15

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Picklist Print

Thursday, June 02, 2011 1:41:46 PM

Page 1

Work Order ID: 70294

Parent Item: D3202-1

Parent Item Name: Cover



Start Date: 6/9/2011

Required Date: 6/17/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:B No Longuer Made In House 05-11-06 JLM
 IPP Rev:C Now on Waterjet 07-04-18 JLM
 IPP Rev:D chg to revC as per dwg 08-04-21 DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.032		Purchased	No			100	sf	171.0000	1.551	39.18316			
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5052-H32 .032 Sheet



B11-6-13

Location	Loc Qty	Loc Code
MAT022	171	
100470	2	
103321	2	
105998	3	
108462	5	
109478	6	
111448	2	
112664	16	
115638	12	
116657	27	
117798	96	

17798

30

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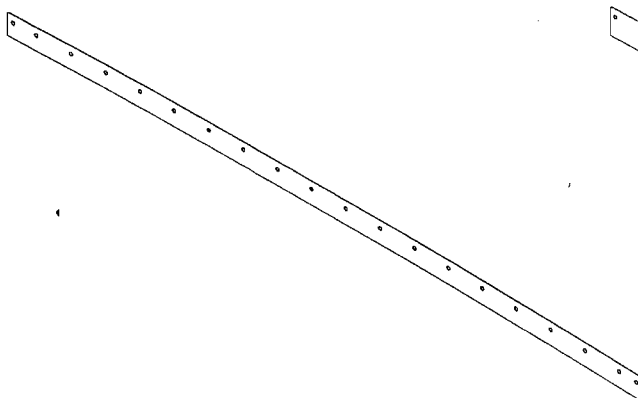
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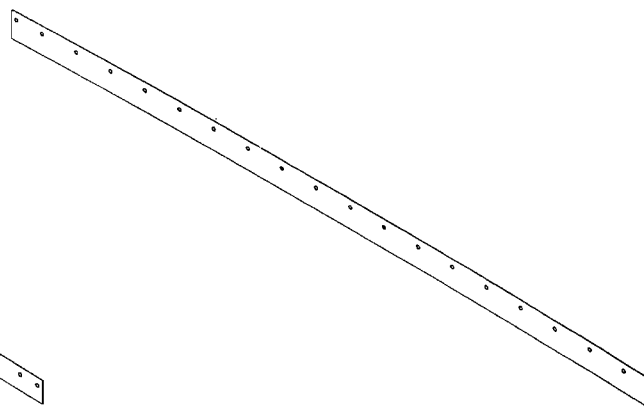
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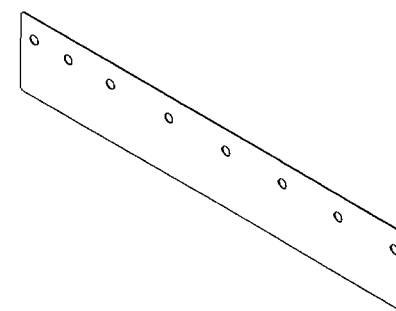
A



D3202-1 COVER



D3202-3 COVER
(COMPOSITE DOOR)



D3202-5 COVER
(HINGE PANEL DOOR MOD)



RELEASED
08.11.10

70294

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF. DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3202-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.56 lbs APPROX FOR -1
: 0.61 lbs APPROX FOR -3
: 0.18 lbs APPROX FOR -5

D	ADD -5 FOR HINGE PANEL DOOR MOD.	AJS	08.11.03
C	ADD -3 FOR COMPOSITE DOOR, REFORMAT ENTIRE DRAWING TO SOLIDWORKS STANDARD, INCORPORATE CHANGE B1 (CLARIFY MID-SPAN DIMENSION)	AJS	08.03.31
B	RE-DESIGN PART NOW CURVED	CP	03.10.16
A	NEW ISSUE	CP	01.01.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3202	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

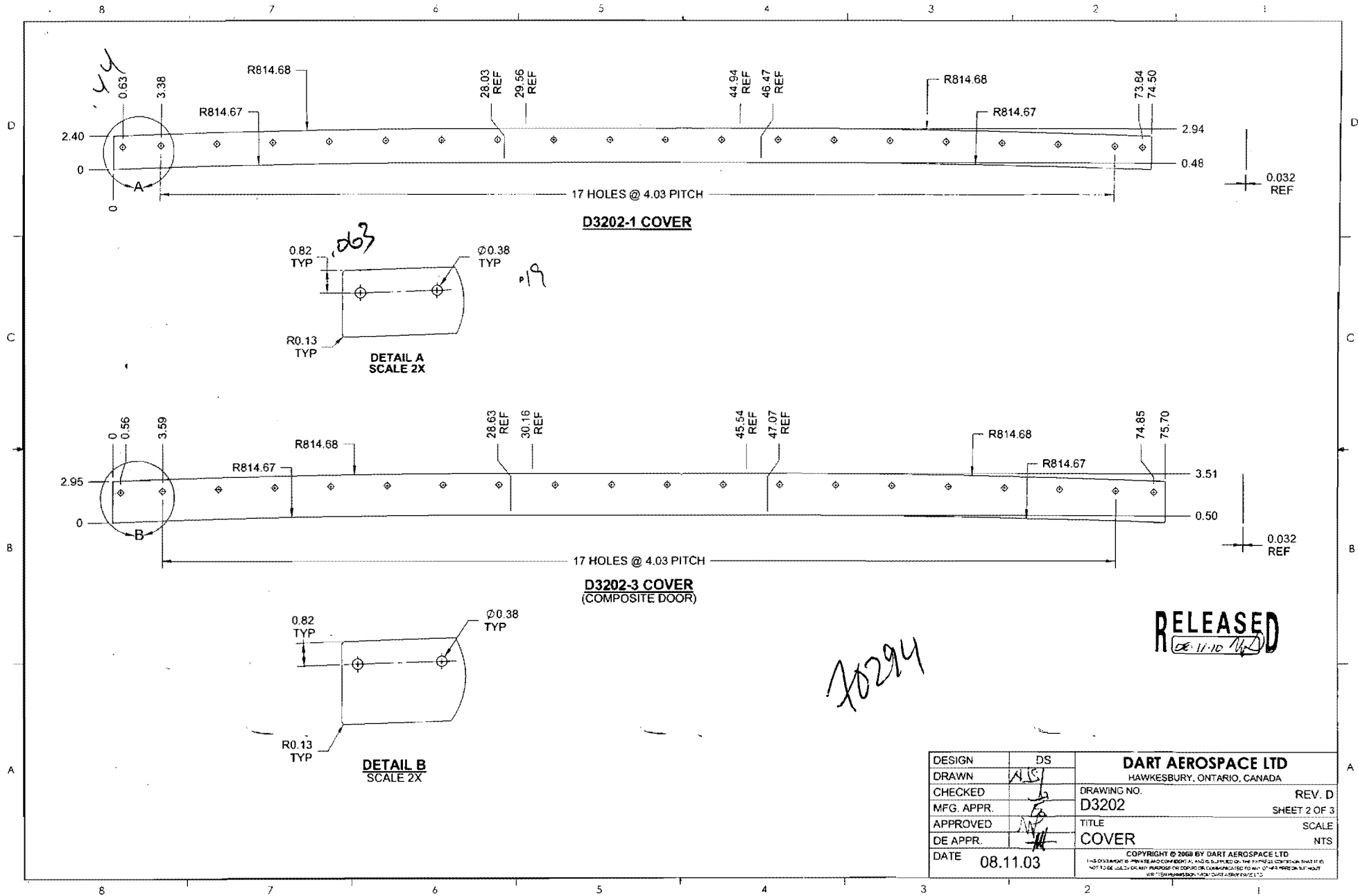
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08-11-10

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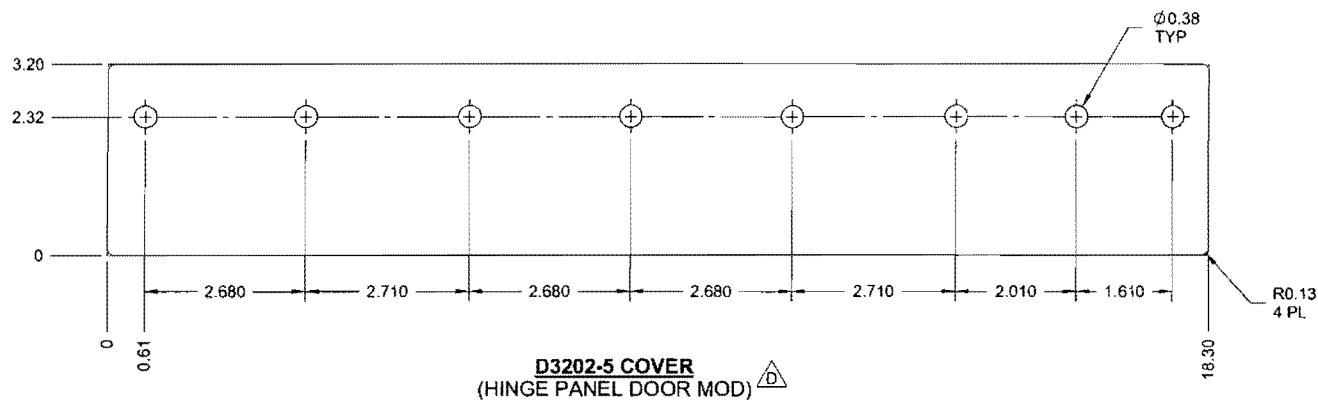
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